

Work Order ID 79576

79576

January-27-12 3:26:50 PM

Item ID: K10111

Accept

*1

Revision ID:

Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012 Start Qty: 5.00

5

Required Date: 10/02/2012 Req'd Qty: 5.00

5

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
--------------------------------	--------------------------	----------------------

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC

Quality Control

Memo

0.00

130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP

PPP D206-642-111

PPP D206-642-113

Location: PK

PPP rev: G

K10111

0.00

140

140

QC

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Work Order ID 79576

79576

Page 1

January-27-12 3:26:50 PM

Item ID: K10111

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Skidtube 206

Stop *NS2*

Start Date: 27/01/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/01/27

Tooling:

Date: _____

Run Start *NR1*

QC:

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

DSI 9583	A
----------	---

K10111	B
--------	---

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP

FOR D206-642-111 CHG007

FOR D206-642-113 CHG002

K10111 CHG003

110

Pick Kit

0.00

110


Packaging

Memo

0.00

Packaging

MLJ 12/03/01

PK 12/3/01 

W/O:		WORK ORDER
DATE	STEP	PROCEDURE CHANGE

Part No: _____ PAR #: _____ Fault Category: _____
Resolution: _____ Disposition: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)		
DATE	STEP	Description of NC Section A	Corrective Action	
			Initial Chief Eng	Action Chief Eng

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-27-12 3:26:54 PM

Page 1

Work Order ID: 79576

79576

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP : F01.11.08 Revised Step 5 and Added Inspection Level

21SM

IPP REV:G

11.09.23 PER REV.B DD VERF:EC

IPP REV:H 11.11.14

AS PER DS19583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A *AN3-41A* Bolt		Purchased	No			110	Each	735.0000	8	40			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST354				735					
				119042				735		119042			
AN4-6A *AN4-6A* Bolt		Purchased	No			110	Each	3,130.000	12	60			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				3130					
				119017				3130		119017			
AN4C5A *AN4C5A* BOLT		Purchased	No			110	Each	370.0000	1	5			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				18					
				112243				18					
				ST355				352					
				112243				252		112243			
				119017				100					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 79576

79576

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

AN5-10A

Purchased

No

110

Each

500.0000

4

20

**

11/20/770

[Handwritten signature]

AN5-10A

Bolt

Location

Loc Qty

Loc Code

ST337

500

118191

80

119547

320

119981

100

AN5-11A

Purchased

No

110

Each

1,139.000

4

20

**

[Handwritten signature]

AN5-11A

Bolt

Location

Loc Qty

Loc Code

ST337

1139

118191

13

119512

1126

AN6-44A

Purchased

No

110

Each

289.0000

2

10

**

11/96/2

[Handwritten signature]

AN6-44A

Bolt

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

282

119036

282

11/90/36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 79576

79576

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D206-651-041

CH17W1

Manufactured No

110

Each

59.0000

1

5

D206-651-041

206A/B GHW

**

79558

Location

Loc Qty

Loc Code

FG

8

78659

8

FG120

1

76578

1

FG122

50

77866

50

D2652

Manufactured No

110

Each

943.0000

16

80

D2652

Bushing

**

76136

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

899

73834

15

73836

36

76132

48

76135

400

77135

400

D2661-1

Manufactured No

110

Each

21.0000

2

10

D2661-1

Saddle, LH Fwd Aft Out 206

**

79199

Location

Loc Qty

Loc Code

MEZZ

7

64559

5

76730

2

ST476

14

78133

4

78134

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 79576

79576

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D2662-1

Manufactured No

110

Each

46.0000

2 10

D2662-1

Saddle, LH In 206

**

79205 8X

79204 2X

Location

Loc Qty

Loc Code

ST435

46

78148

10

78149

10

78150

10

78151

10

78152

6

D2712

Manufactured No

110

Each

1,362.000

10 50

D2712

Set Screw

**

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1312

76065

1312

D2884

Manufactured No

110

Each

319.0000

2 10

D2884

Saddle Spacer

**

76065

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

309

76751

309

76751

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 79576

79576

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D2885

Manufactured No

110

Each

310.0000

2

10

**

D2885

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

300

76752

300

76752

D3413-1

Manufactured No

110

Each

89.0000

1

5

**

D3413-1

Ring

Location

Loc Qty

Loc Code

ST420

2

66387

1

70773

1

ST464

87

75478

28

76754

59

75478

MS21042L3

Purchased

No

110

Each

5,393.000

8

40

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

5393

117441

16

117885

32

118451

5

118927

3

119017

4917

119075

420

119017

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 79576

79576

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

110

Each

6,617.000

12

60

MS21042I 4

**

Nut

Location

Loc Qty

Loc Code

ST300

6617

117441

51

117601

237

118451

133

119017

1196

119075

5000

119078

MS21042L6

Purchased

No

110

Each

1,202.000

2

10

MS21042I 6

**

Nut

Location

Loc Qty

Loc Code

ST300

1202

117677

25

118384

3

118927

48

119075

926

120308

200

119075

NAS1149C0463R

Purchased

No

110

Each

1,242.000

1

5

NAS1149C0463R

**

Washer

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

1241

117735

241

119097

1000

117735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 79576

79576

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0363J

Purchased

No

110

Each

3,315.000

8

40

NAS1149D0363.I

Washer

**

Location

Loc Qty

Loc Code

ST298

3315

117601

61

118077

1

118612

18

119537

942

120142

1293

120308

1000

120308

NAS1149D0463J

Purchased

No

110

Each

4,267.000

24

120

NAS1149D0463.I

Washer

**

120647

Location

Loc Qty

Loc Code

ST298

4267

116805

0

118384

135

118612

3

119075

3960

119097

169

NAS1149D0563J

Purchased

No

110

Each

4,502.000

8

40

NAS1149D0563.I

Washer

**

12/3/12

Location

Loc Qty

Loc Code

ST298

4502

118206

510

118614

1000

119546

2000

119717

992

119717

January-27-12 3:26:54 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January-27-12 3:26:54 PM

Work Order ID: 79576

79576

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0663J

Purchased

No

110

Each

1,076.000

4

20 ✓

NAS1149D0663.J

Washer

**

Handwritten signature and date 1/23/12

Location

Loc Qty

Loc Code

ST298

1076

119075

1076

119075

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	140	DRAWING NO.	REV. C
MFG. APPR.	EE	K10111	SHEET 1 OF 1
APPROVED	140	TITLE	SCALE
DE APPR.	140	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	